

Work Order ID 57250

March 31, 2010 10:01:18 AM

**PRELIMINARY
ISSUE**

Page 1

Item ID: D4091-1

Revision ID:

Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00

Required Date: 01/04/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4091

PAT

A

Rev. 05.20



100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

DJP 10/03/31

6 6

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: AA

DWG REV: A

0.00

DJP 10/03/31

6 6

DEBURR

Work Order ID 57250

March 31, 2010 10:01:18 AM



Page 2

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Work Order ID 57250

March 31, 2010 10:01:18 AM



Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

M113170.
START 8:20
QC 320°
FINISH 9:50

0.00

BR 10-4-1

6 4.

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

QC APPROVAL

P. J. 10.06.22

170

Identify as per dwg & Stock Location

0.00



Packaging

Packaging

Memo

0.00

u 10.04.22

Work Order ID 57250

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Page 4

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.03.31 AUTH WRELEASED QR DATE 10.04.21~~10/04/23~~
10/06/02

WLD 22

Picklist Print

March 31, 2010 10:01:18 AM

Page 1

Work Order ID: 57250

Parent Item: D4091-1

Parent Item Name: Mounting Lug



Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Start Date: 31/03/2010


Required Date: 01/04/2010

Start Qty: 6.00

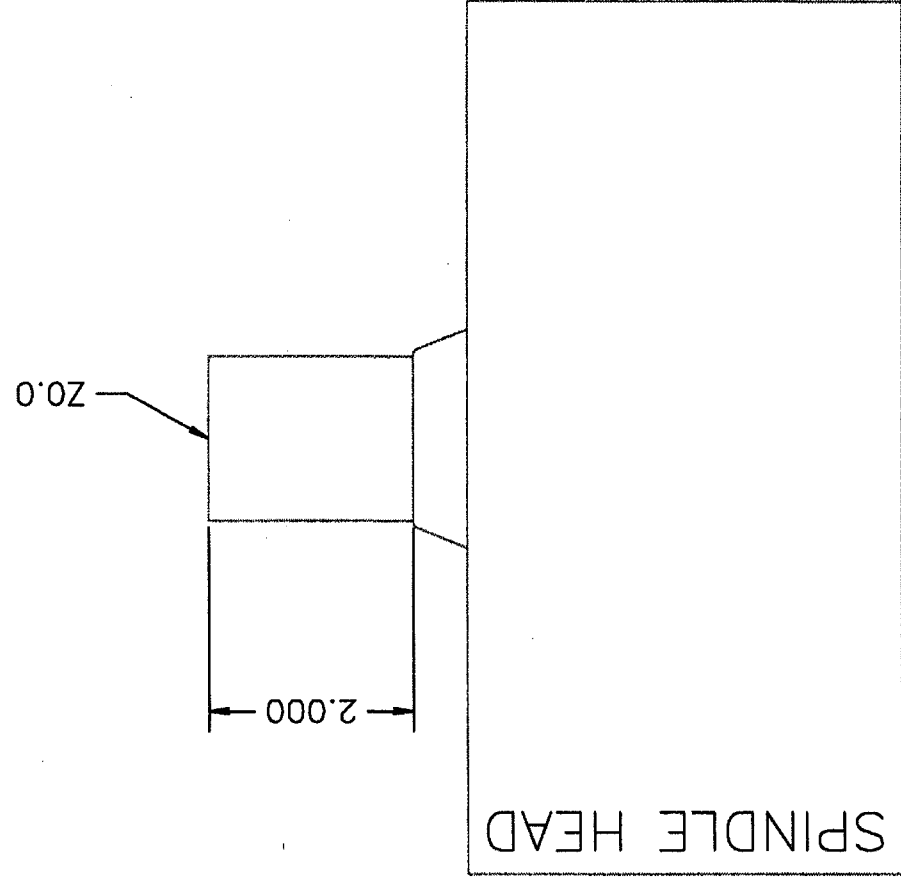
Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	f	556.0417	0.7901			
Lug Extrusion												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT06	556.0417432	
43722	173.462806	
44529	5.7731	
45800	376.805837	

0.7901 (f) 
10/03/31

D3317-1-3 WASHER



DART AEROSPACE LTD		Work Order:	57250
Description: <i>Mounting Lug</i>		Part Number:	D4091-1
Inspection Dwg:	Rev: <i>PA1</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.050	± 0.020	0.05	✓			TYP Around Pad
4.45	± 0.030	4.452	✓			
1.38	± 0.030	1.377	✓			
0.27	± 0.030	0.264	✓			REF
R1.20	± 0.030	1.20	✓			
0.735	± 0.010	0.726	✓			REF
0.293	± 0.010	0.289	✓			
3.700	± 0.010	3.699				
$\phi 0.257$	$\pm 0.006 / -0.001$	0.259	✓			4PL
R0.34	± 0.030	0.34	✓			
0.375	± 0.010	0.375	✓			
0.625	± 0.010	0.625	✓			
2.310	± 0.010	2.314	✓			REF
1.91	± 0.030	1.913	✓			
R0.63	± 0.030	0.63	✓			2PL
35°	$\pm 1/2^\circ$	35°	✓			TYP
$\phi 0.257$	$\pm 0.006 / -0.001$	0.259	✓			
R0.400	± 0.010	0.400	✓			
0.688	± 0.010	0.689	✓			

Measured by: <i>DJP</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>10/03/31</i>	Date: <i>10/03/31 10/04/01</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue <i>to Polym Dwg only</i>	KJ/JLM	

8 7 6 5 4 3 2 1

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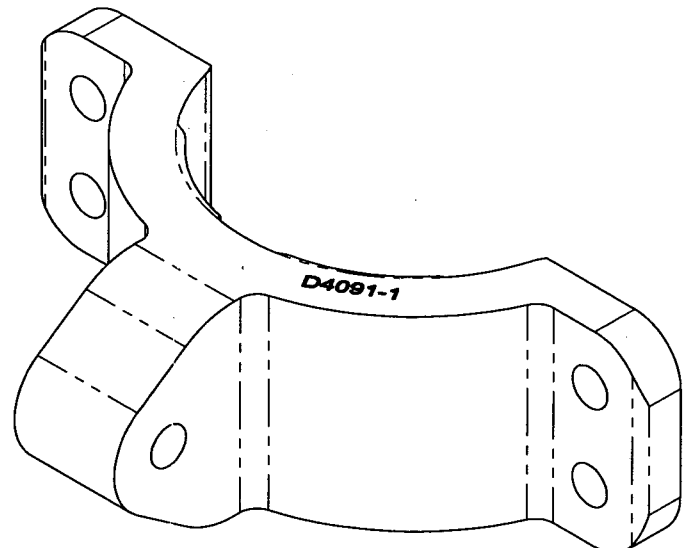
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D4091-1 MOUNTING LUG

PRELIMINARY ISSUE

10.03.29

- NOTES:
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
 - 7) WEIGHT: 0.31 lbs

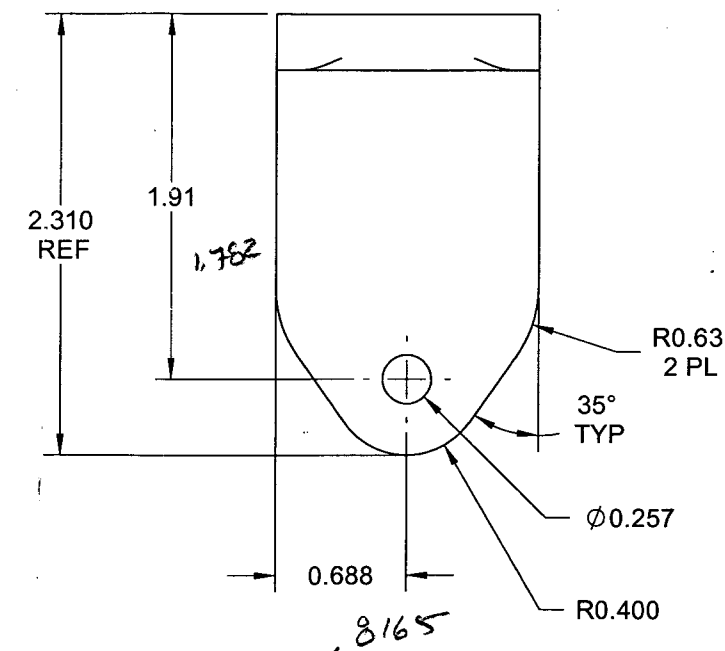
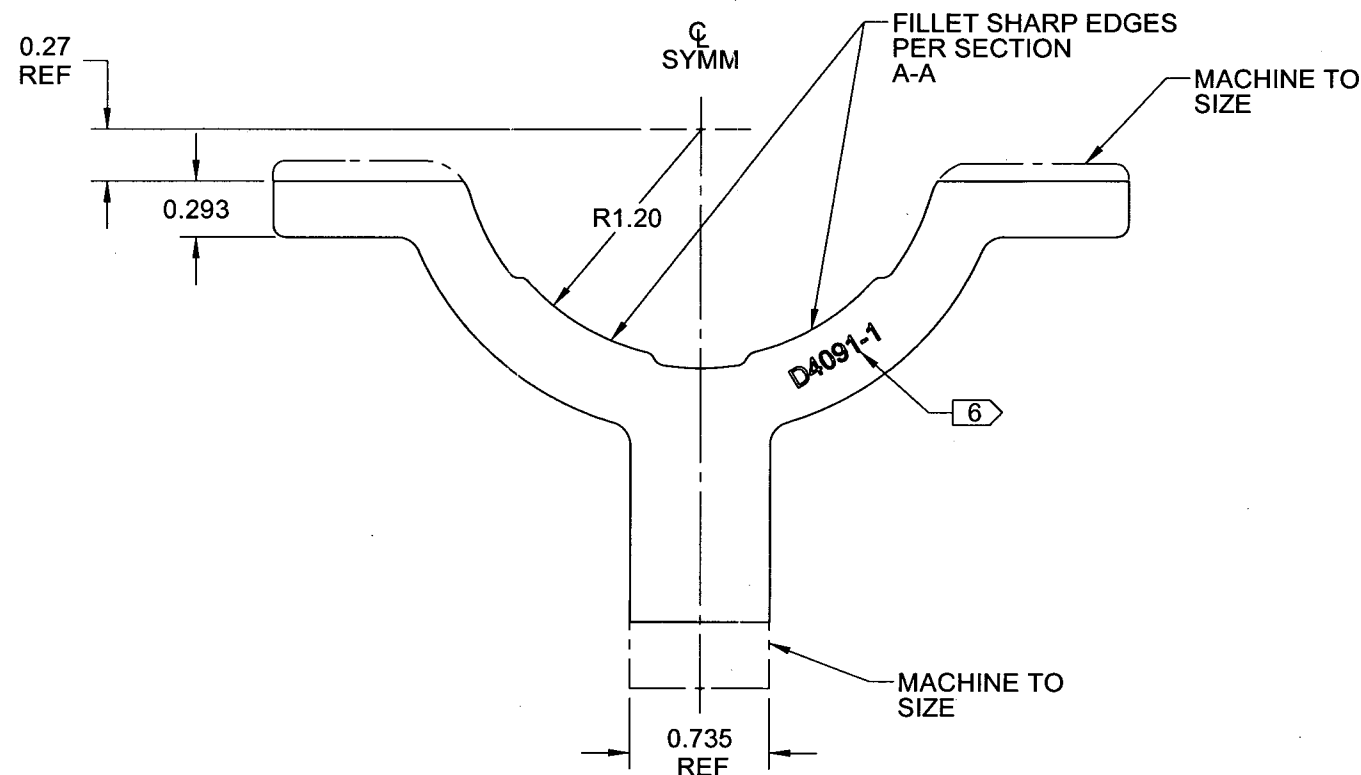
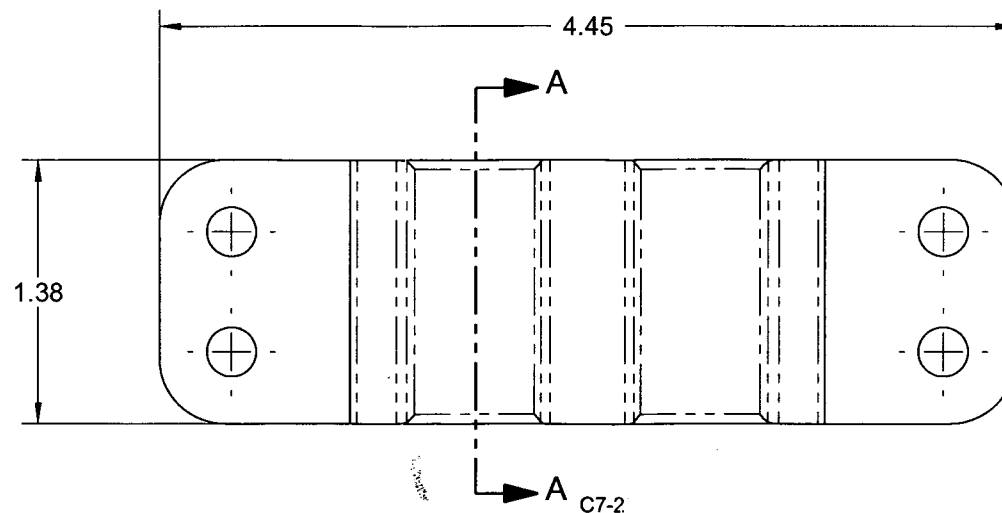
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REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CP			
CHECKED		DRAWING NO.	REV. A	PA1
MFG. APPR.		D3910	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	10.03.29
DE APPR.		MOUNTING LUG	NTS	
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8 7 6 5 4 3 2 1



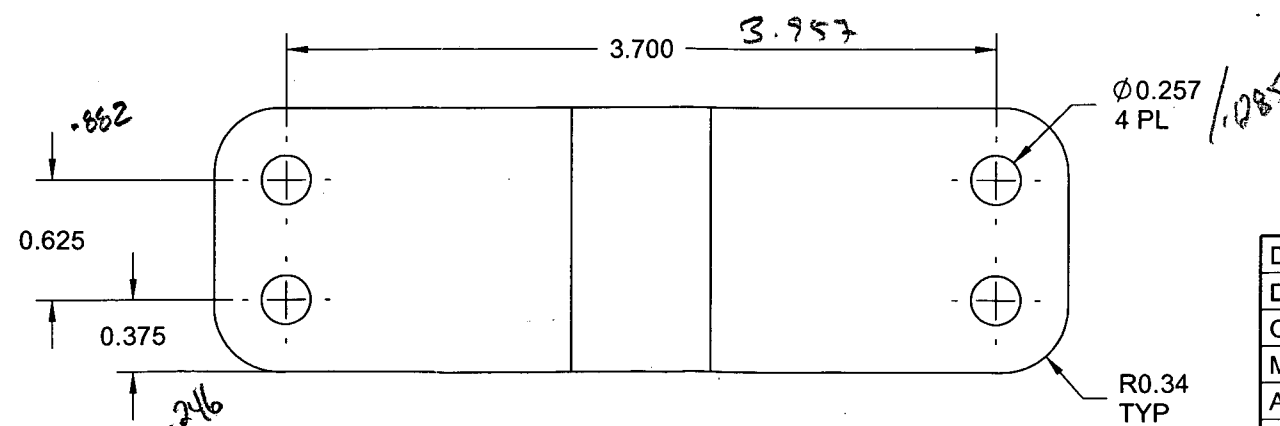
R0.03-R0.07
TYP AROUND PAD

SECTION A-A C5-2



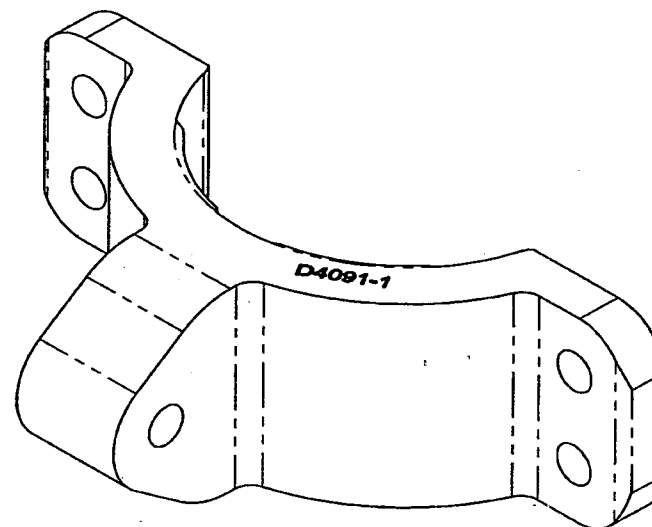
PRELIMINARY ISSUE

P 10.03.29



D4091-1 MOUNTING LUG

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DRAWN	CP		
CHECKED		DRAWING NO. D3910	REV. <i>A</i>
MFG. APPR.			SHEET 2 OF 2
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D4091-1 MOUNTING LUG

alp 57250

RELEASED
2010-04-28
wp

NOTES:

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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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MFG. APPR.		D4091	SHEET 1 OF 2
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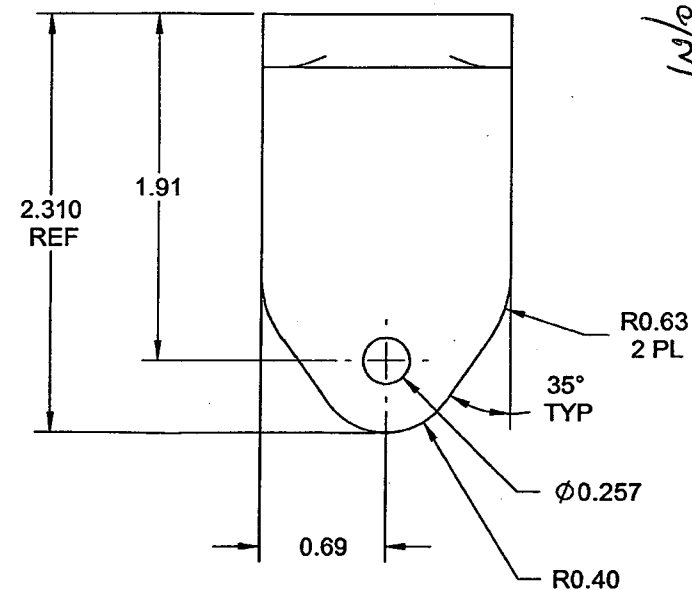
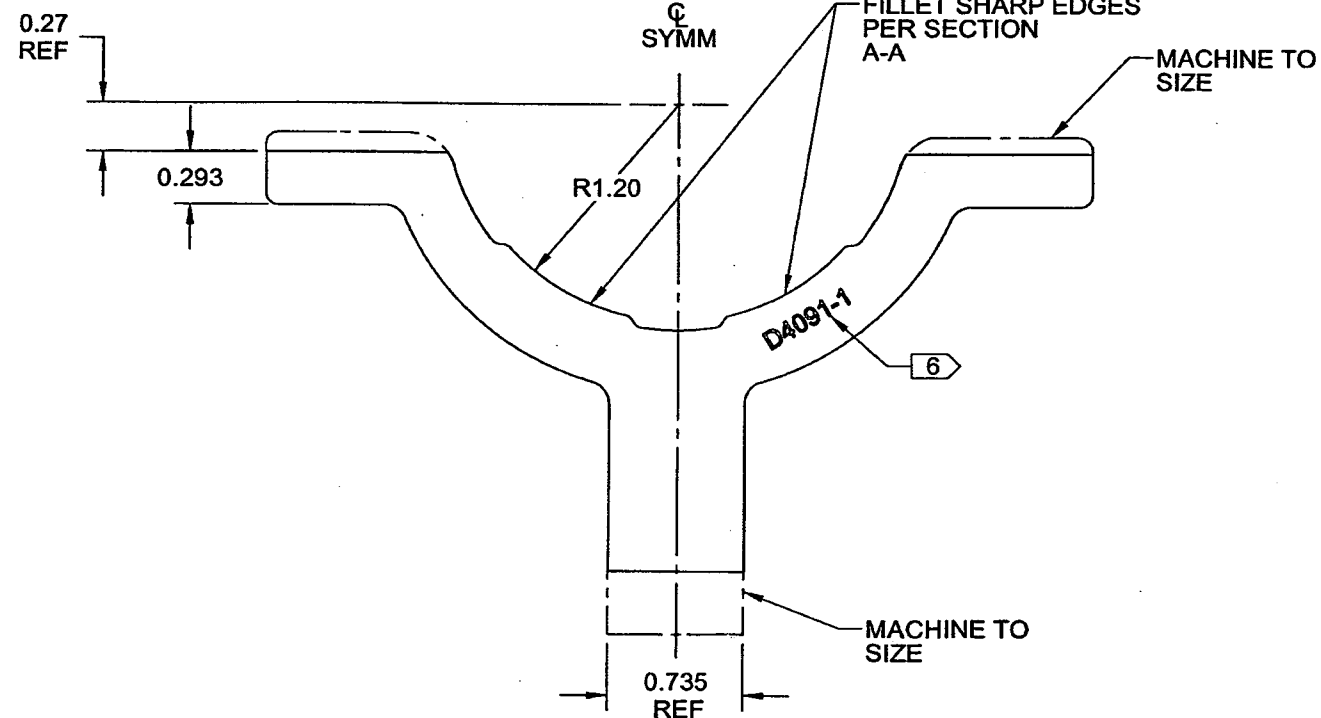
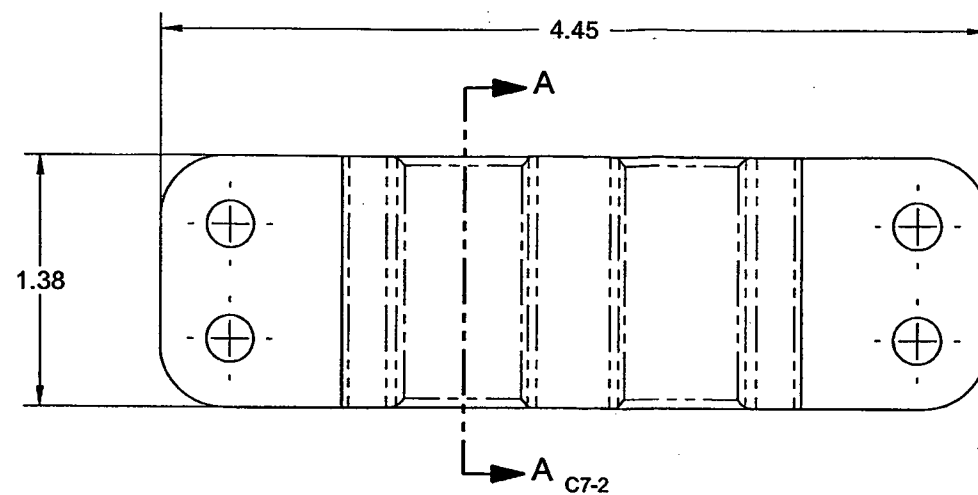
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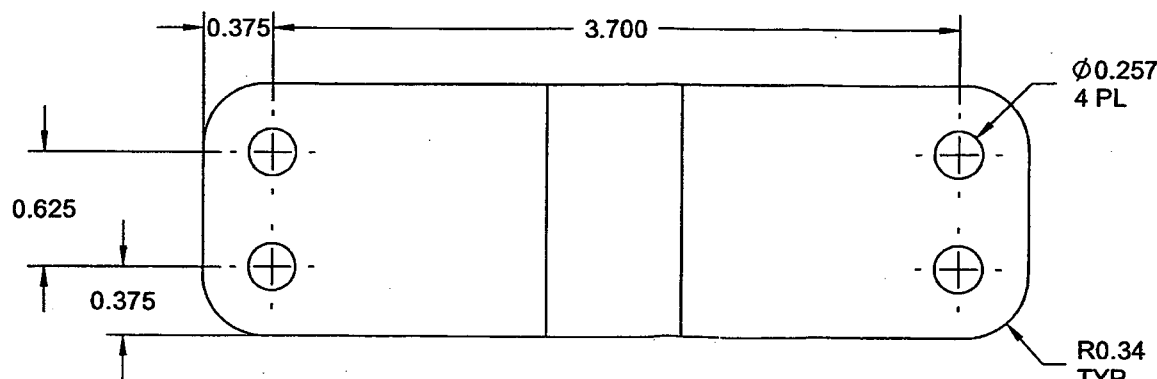


R0.03-R0.07
TYP AROUND PAD

SECTION A-A C5-2





W/ 51250



D4091-1 MOUNTING LUG

RELEASED
2010-04-20

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4091	SHEET 2 OF 2
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